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D2332-041
Job Sheet 188665



Part No: D2332-041

Job Qty: 6-pcs

Part Name: Lid Prop Assembly 6.69"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF IPP Rev:C 08-06-02 add comment DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Small Fab - 1	6 pcs	1/25/19		0.32	1.88	Small Fab - 1			58
							Small Fab - 2			9-89
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
110	Small Fab - Brake NC - B4B	6 pcs	1/25/19		0.00	0.68	Small Fab - Brake - 1 - B4B			DAS 58
							Small Fab - Brake - 2 - B4B			9-89
							Small Fab - Brake - 3 - B4B			DAS
120	Small Fab - 2 - B4B	6 pcs	1/25/19		0.00	1.88	Small Fab - 1 - B4B			58
							Small Fab - 2 - B4B			9-89
							Small Fab - 3 - B4B			
							Small Fab - 4 - B4B			
							Small Fab - 5 - B4B			
							Small Fab - 6 - B4B			
							Small Fab - 7 - B4B			
130	QC 5	6 pcs	1/25/19		0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			DAS
							QC 5 - 24			24
							QC 5 - 3			9-89
							QC 5 - 38			
							QC 5 - 42			
							QC 5 - 43			
							QC 5 - 49			

P.T.O.

					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
140 Large Fab - Welded Assy-2-B4B	6 pcs	1/25/19	0.00 1.49		Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	DAS
					Large Fab - 4 - B4B	24
					Large Fab - 5 - B4B	9-89
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
150 QC 9	6 pcs	1/25/19	0.00 0.00		QC 9 - 10	
					QC 9 - 18	BE
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	
					QC 9 - 9	
160 QC 5	6 pcs	1/25/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	JAN 21 2019 DAS
					QC 5 - 9	68
					QC 5 - 50	9-89
					QC 5 - 30	
170 Small Fab - 3 - B4B	6 pcs	1/25/19	0.00 1.88		Small Fab - 1 - B4B	DAS
					Small Fab - 2 - B4B	58
					Small Fab - 3 - B4B	9-89
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
180 QC 5	6 pcs	1/25/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	DAS
					QC 5 - 38	38
					QC 5 - 42	9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	

QC 5 - 58
QC 5 - 68
QC 5 - 9
QC 5 - 50
QC 5 - 30

190 Packaging 3-1 - Stock - B4B 6 1/25/19 0.00 0.00
pcs

Packaging 3 - 1 - B4B
Packaging 3 - 2 - B4B
Packaging 3 - 3 - B4B
Packaging 3 - 4 - B4B
Packaging 3 - 5 - B4B
Packaging 3 - 6 - B4B
Packaging 3 - 7 - B4B
Packaging 3 - 8 - B4B
Packaging 3 - 9 - B4B
Packaging 3 - 10 - B4B
Packaging 3 - 11 - B4B
Packaging 3 - 12 - B4B
Packaging 3 - 13 - B4B
Packaging 3 - 14 - B4B
Packaging 3 - 15 - B4B
Packaging 3 - 16 - B4B
Packaging 3 - 17 - B4B
Packaging 3 - 18 - B4B
Packaging 3 - 19 - B4B
Packaging 3 - 20 - B4B
Packaging 3 - 21 - B4B
Packaging 3 - 22 - B4B
Packaging 3 - 23 - B4B
Packaging 3 - 24 - B4B
Packaging 3 - 25 - B4B
Packaging 3 - 26 - B4B
Packaging 3 - 27 - B4B
Packaging 3 - 28 - B4B
Packaging 3 - 29 - B4B
Packaging 3 - 30 - B4B
Packaging 3 - 31 - B4B
Packaging 3 - 32 - B4B
Packaging 3 - 33 - B4B
Packaging 3 - 34 - B4B
Packaging 3 - 35 - B4B

FP-001 Jul 19-0-22

200 QC 21 - SA 6 1/25/19 0.00 0.00
pcs

QC 21 - SA - 21

DAE
21

Part Op 100 - (Small Fab) 1- Cut D2332-7 and D2332-5 to lenght as per dwg D2332. 2- Cut D2332-11 using 1/2" A/R tubing 1/19
Descriptions: 7.735" long. 3- Deburr.

110 - (Punch ends and deburr as per dwg) Punch and form D2332-11 to lenght as per dwg D2332 using DT8012 (need 2 per ass'y)

120 - (Small Fab) 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no forein objects inside tube

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Weld per dwg A/R S.S. rod Batch: 138840) Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)

*****ensure nothing is inside of tube before welding***** S.S Rod batch: 138840

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Small Fab) 1- Tumble 2- Assemble as per dwg D2332

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.250	304 SS Round bar .250	.6000 ft (.1 ea)	100-Small Fab - 1	
M304TR1.000W.049	304 Round Tube 1.00 X .049W	2.5800 ft (.43 ea)	100-Small Fab - 1	5012847 3135660

TR0.500W.035	304 Round Tube .500 X .035W	7.5000 ft (1.25 ea)	110-Small Fab - Brake NC - B4B
AN4-4A	Bolt	5 Ea (1 ea)	170-Small Fab - 3 - B4B
MS21042L4	Nut	6 Ea (1 ea)	170-Small Fab - 3 - B4B
NAS1149D0416J	Washer	18 Ea (3 ea)	170-Small Fab - 3 - B4B

5084601
5084601 5082258
3130396
131511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	M304R0.250	1	15	0
	M304TR1.000W.049	3	20	0
110-Small Fab - Brake NC - B4B	M304TR0.500W.035	8	32	0
170-Small Fab - 3 - B4B	AN4-4A	6	30	0
	MS21042L4	6	1,978	0
	NAS1149D0416J	18	2,248	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lid Prop Assembly	5.000Inches $\pm$ 0.030	5.030 4.970		
2	Lid Prop Assembly	1.250Inches $\pm$ 0.010	1.260 1.240		
3	Lid Prop Assembly	6.690Inches $\pm$ 0.010	6.700 6.680		

Plex 1/14/19 11:40 AM Dart.lajeunesse.marie